

Date: Friday, 19/06/2009 10:26:53 AM
 User: Linda Lacelle

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : RIB ASSY (BASKET END)
 Job Number : 48668
 Estimate Number : 13666
 P.O. Number :
 This Issue : 19/06/2009 S.O. No. :
 Prsht Rev. : NC Part Number : D3825041
 First Issue : / / Type : LARGE FAB ASSY Drawing Number : D3825 REV A
 Previous Run : 48430 Drawing Revision : A
 Material :
 Due Date : 26/06/2009 Qty: 6 Um: Each
 Written By :
 Checked & Approved By :
 Comment : Est Rev:A 08-12-01 new issue DD verified by:EC

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
✓ 1.0	D23273	Spacer Bushing
	Comment: Qty.: 1.0000 Each(s)/Unit Total : 6.0000 Each(s) Spacer Bushing Batch: <u>B44274</u> <i>SAD 09-06-19</i>	
✓ 2.0	D37591	Bushing
	Comment: Qty.: 1.0000 Each(s)/Unit Total : 6.0000 Each(s) Bushing <u>B 48331</u> <i>SAD 09-06-19</i>	
✓ 3.0	M304TS0750W065	304 SQ Tube .75x.75x.065W
	Comment: Qty.: 2.2313 f(s)/Unit Total : 13.3875 f(s) 304 SQ Tube .75x.75x.065W batch: <u>m112051</u> <i>SAD 09-06-19</i>	
4.0	LARGE FAB 1	LARGE FABRICATION RESOURCE 1
	Comment: LARGE FABRICATION RESOURCE 1 ✓ 1- cut D3825-1 rib as per dwg D3825 ✓ 2- drill hole (3/16") in D3825-1 using DT9438 jig and open to finish size as per dwg and hole for bushing as per dwg ✓ 3- c'sink hole as per dwg ✓ 4- remove identification markings ✓ 5- deburr <i>SAD 09-06-21 (6)</i>	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Drawing Name: RIB ASSY (BASKET END)

Job Number: 48668

Part Number: D3825041

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

50766/22 (x6)

6.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1- weld D2327-3 spacer bushing and D3759-1 bushing as per dwg D3825

A/R ER316 S.S. Rod Batch: H108775

2- grind bushing weld flush where indicated on dwg D3825

3- deburr if necessary

Sp 09.06.23 (6x)

7.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

PD 09.06.23 (C)

8.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

509106/23 (x6)

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: WA

SAD 09-06-23 (6)

10.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

09/06/23

Job Completion



MF 09-06-23

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NOTE: Date & initial all entries

D3825-1
RIB

0.94

D3759-1
BUSHING

D2327-3
SPACER BUSHING

6.50
REF

11.00
REF

D3825-041 RIB ASSY (BASKET END)

W/O 48668

RELEASED
08/11/18 JN

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D3825	SHEET 2 OF 3
APPROVED		TITLE	SCALE
DE APPR.		RIB ASSY (BASKET END)	NTS
DATE	08.09.23	<small>COPYRIGHT © 2008 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD</small>	

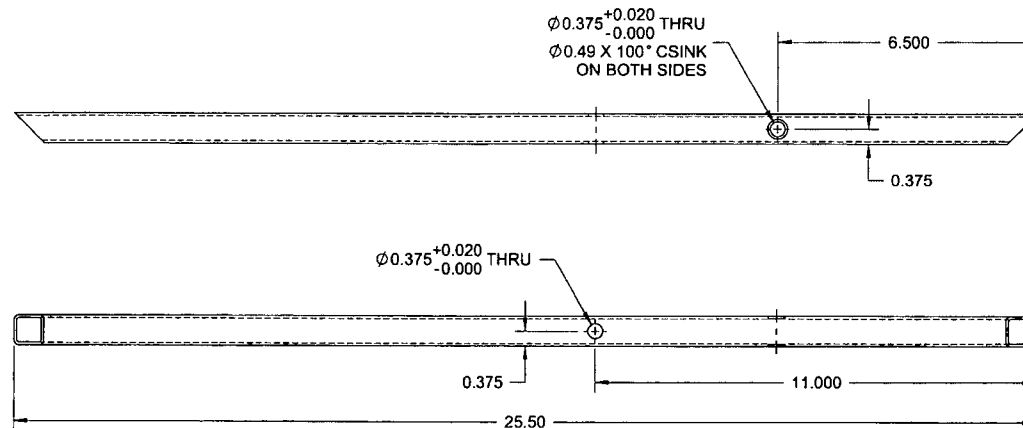
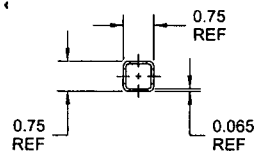
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D3825-1 RIB

NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SQUARE TUBE, 0.75 X 0.75 X 0.065 WALL
REF. DART SPEC. M304TS0.750W0.065
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 1.18 lbs

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D3825	SHEET 3 OF 3
APPROVED		TITLE	SCALE
DE APPR.		RIB ASSY (BASKET END)	NTS
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RELEASED
08/11/13 NW

U6 48668

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